Work Order ID 73385

Wednesday, August 31, 2011 1:26:07 PM

Item ID: D350-636-012 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Skidtube RH

Start Date: 8/31/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/15/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/08/31 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy blue file and type labels per PPP D350-636-012 CHG 006								

Draw Nbr	Revision Nbr
D2750	F
D3492	C

8 11/10/12

for MLJ 11-10-12

73385

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes	0.00							
Skidtubes									

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

MO/BB 11-09-29

11/09/99

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M118736 BE 11/10/03 12-Grind welds flush as per Dwg D2750 BB 11/19/05								
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00	8 11/10/05						
130 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	8 11/10/05			(7)			

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							DL 11/10/05
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							DP 11-10-5
Quality Control									

Dart Aerospace Ltd

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Skidtubes	Skidtubes								
Skidtubes		0.00							

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015
A/R ☐ Sikaflex-291 batch: 118393 ☐☐☐
exp. date: 12/04/05 DC 11/10/05

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)
A/R☐ Aluminum Rod batch: M118736 BE 11/10/06

9- At section AP-AP drill out x-bolt spacer to 0.404" BBN 11/10/06

10-Grind welds flush as per Dwg D2750 DL 11/10/06

11-Spot face ground handling holes section (total of 4 places per side) as per

BB 11/10/05

DP 11-10-6

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750 12-Deburr holes	DP	11-10-6						
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00 8/11/07							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 8/11/07							

Dart Aerospace Ltd

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	BR	11-10-7.	
HandFinish	**Memo**	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	Ø	m-f	11/10/11
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 7:50 OVEN TEMPERATURE: 320 01= FINISH TIME: 8:20								
M118439									
210	QC3- Inspect Part Finish	0.00				1	BR	11-10-12	
QC	**Memo**	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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H:\fFQRMS\Quality Assurance\approved QA\NCRWO RevE

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
HandFinish	HandFinishing					1	BL	11-10-12.	
Hand Finishing	**Memo**	0.00							

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"
batch: N/A.

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: 118393
EXP DATE: 12-5

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: 110878.

6-Coat all exposed fasteners with "LPS Procyon"
batch: 114596.

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	8/11/10/12						
250 Packaging Packaging	Pick Kit **Memo**	0.00 0.00				11/10/12			
260 QC Quality Control	QC4- 100% Inspect kits for completeness **Memo**	0.00 0.00	8/11/10/12						

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
Packaging	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00					11/10/12		
QC	**Memo**	0.00							
Quality Control									

11-10-12

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, August 31, 2011 1:26:03 PM

10

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:I□02.09.25□Rearranged procedure steps□KJ□
IPP Rev:J 06-03-29 As per Rev D EC
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No				Each	1,925.000		38	BK 11-10-12		
Insert				118696.						38.			

Location		Loc Qty	Loc Code
ST282		1925	
	110768	62	
	117717	9	
	118386	860	
	118696	994	

AN3C5A		Purchased	No			230	Each	1,261.000	34	34	BK 11-10-12.		
Bolt													

Location		Loc Qty	Loc Code
FP-A		7	
	115835	7	
ST350		1254	
	116419	28	
	116549	30	
	117343 ✓	462	
	117764	222	
	117872	12	
	118451	500	

34.

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Wednesday, August 31, 2011 1:26:03 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C6A BOLT	Purchased	No	230	Each	328.0000	4	4	BL 11-10-12

Location		Loc Qty	Loc Code	
FP-A		1		
	111982	1		
ST351		327		
	111982	2		
	116419	23		
	116549	2		
	116704	12		
	117619	22		
	117688	16		
	117872	50		
	118422 ✓	200		4.

AN6C44A BOLT	Purchased	No	230	Each	115.0000	4	4	BL 11-10-12

Location		Loc Qty	Loc Code	
FG		2		
	103964	2		
ST344		113		
	117950	13		
	118112	2		
	118332 ✓	48		4
	118387	50		

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Picklist Print

Wednesday, August 31, 2011 1:26:03 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN8C35A BOLT		Purchased	No		230	Each	131.0000	1	1	BR 11-10-12

Location	Loc Qty	Loc Code	
FP	95		
117511	29		1
118286	66		
FP-A	1		
115960	1		
ST345	34		
117834	34		
ST346	1		
114442	0		
115188	0		
115960	1		

AN960C10L washer	NAS1149C0332R	Purchased	No	118354.	230	Each	0.0000	38	38	38. BR 11-10-12
D2745 Bushing		Manufactured	No		230	Each	309.0000	8	8	BR 11-10-12.

Location	Loc Qty	Loc Code	
FP-A	147		
69529	147		8.
ST023	162		
71835	162		

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Picklist Print

Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3488-042	Manufactured	No	230	Each	17.0000	1	1	BR 11-10-12
Blade Fitting Assembly, RH								

Location	Loc Qty	Loc Code	
FP008	17		
62003	1		
68109	7		
69904 ✓	9		1

D3492-1	Manufactured	No	230	Each	72.0000	8	8	BR 11-10-12.
Plug								

Location	Loc Qty	Loc Code	
FP 73402	72		8.
69531	8		
71836	64		

D3492-3	Manufactured	No	230	Each	161.0000	8	8	BR 11-10-12.
Plug								

Location	Loc Qty	Loc Code	
FP	161		
70692	4		
71838 ✓	100		8.
72126	57		

D3535-25	Manufactured	No	230	Each	16.0000	1	1	BR 11-10-12
Wearshoe								

Location	Loc Qty	Loc Code	
FP018	16		
62233	1		
69743 ✓	15		1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3536-25	Manufactured	No	230	Each	18.0000	1	1	BK 11-10-12.
Gasket								

Location		Loc Qty	Loc Code	
FP012	74526.	18		1
	70780	18		

D3537-1	Manufactured	No	230	Each	117.0000	3	3	BK 11-10-12.
Wearpad								

Location		Loc Qty	Loc Code	
FP001	73395	60		3
	72124	60		
FP016		50		
	68944	0		
	70687	50		
FP017		7		
	69817	5		
	70686	2		

D3631-1	Manufactured	No	230	Each	251.0000	8	8	BK 11-10-12.
Washer								

Location		Loc Qty	Loc Code	
ST072		251		
	68062 ✓	251		8

D3791-1	Manufactured	No	230	Each	10.0000	1	1	BK 11-10-12.
Wearplate								

Location		Loc Qty	Loc Code	
FP017		10		
	62239	2		
	69282 ✓	8		1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3793-1	Manufactured	No		230	Each	16.0000	1	1	BR 11-10-12
Wearshoe									

Location	Loc Qty	Loc Code	
FP018 73422	16		1
70781	16		

D3793-3	Manufactured	No		230	Each	22.0000	1	1	BR 11-10-12
Wearshoe									

Location	Loc Qty	Loc Code	
FP018	22		
70813 ✓	10		1
72160	12		

D3794-1	Manufactured	No		230	Each	20.0000	1	1	BR 11-10-12
Gasket									

Location	Loc Qty	Loc Code	
FP010	20		
70779 ✓	20		1

D3794-3	Manufactured	No		230	Each	11.0000	1	1	BR 11-10-12
Gasket									

Location	Loc Qty	Loc Code	
FP018	11		
70812 ✓	11		1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21043-6	Purchased	No		230	Each	577.0000	4	4	BR 11-10-12.
NUT									

Location		Loc Qty	Loc Code	
FG		20		
	103693	20		
ST301		557		
	112314 ✓	347		4.
	117887	10		
	118384	200		

MS21083C8	Purchased	No		230	Each	121.0000	1	1	BR 11-10-12
NUT									

Location		Loc Qty	Loc Code	
FP-B		1		
	115884	1		
ST293		35		
	118077 ✓	35		1
ST303		85		
	115884	0		
	117423	5		
	118354	30		
	118614	50		

NAS1149C0832R	Purchased	No		230	Each	363.0000	1	1	BR 11-10-12.
WASHER									

Location		Loc Qty	Loc Code	
FP-B		33		
	114915 ✓	33		1
ST297		330		
	114915	330		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

NAS1515H3L WASHER	Purchased	No	230	Each	228.0000	4	4	BR 11-10-12

Location	Loc Qty	Loc Code	
FG	40		
102472	40		
ST277	188		
113362	88		
118686 ✓	100		4.

NAS1611-010 O-RING	Purchased	No	230	Each	238.0000	8	8	BR 11-10-12

Location	Loc Qty	Loc Code	
FP	221		
117460	8		
118077	13		
118612 ✓	200		8
FP-A	17		
110915	14		
115589	3		

NAS1611-013 O-RING	Purchased	No	230	Each	216.0000	8	8	BR 11-10-12

Location	Loc Qty	Loc Code	
FP	55		
117291	2		
117887	53		
FP-A	161		
116582	5		
118384 ✓	156		8.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN8C21A BOLT	Purchased	No	250	Each	59.0000	2	2	

Location	Loc Qty	Loc Code
ST344	9	
117764	9	
ST345	50	
118045	50	

D2741 Blade, 350 Skidtube	Manufactured	No	250	Each	10.0000	1	1	B70667

Location	Loc Qty	Loc Code
ST466	10	
69133	10	

D3493-1 Washer	Manufactured	No	250	Each	89.0000	2	2	

Location	Loc Qty	Loc Code
ST062	89	
70697	49	
71846	40	

D3532-1 Spacer	Manufactured	No	250	Each	17.0000	2	2	11/10/12

Location	Loc Qty	Loc Code
ST065	17	
69895	17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21083C8	Purchased	No	250	Each	121.0000	2	2	
NUT								

Location	Loc Qty	Loc Code	
FP-B	1		
115884	1		
ST293	35		
118077	35		
ST303	85		
115884	0		
117423	5		
118354	30		2
118614	50		

NAS1149D0863J	Purchased	No	250	Each	166.0000	2	2	4/10/12
WASHER								

Location	Loc Qty	Loc Code	
ST298	166		
118078	166		2

D2600-3-BENT	Manufactured	No	110	Each	9.0000	1	1	
Extrusion Bent								

Location	Loc Qty	Loc Code		
LG 73253	9		1	11-09-29
66875	8			
72153	1			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Wednesday, August 31, 2011 1:26:04 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2744	Manufactured	No	110	Each	81.0000	1	1	BE 11/10/03
Cap								

Location		Loc Qty	Loc Code
LG002		25	
	62715	1	
	70881	24	
WA		56	
	71861	56	1

D2739	Manufactured	No	160	Each	7.0000	1	1	1 OR EBR X 11/10/05
350 I Beam								

Location		Loc Qty	Loc Code
LG	72156	7	
	70823	7	

D2743	Manufactured	No	160	Each	232.0000	8	8	BE 11/10/06
Crossbolt Spacer								

Location		Loc Qty	Loc Code
LG		174	
	69818	9	8
	71839	165	
LG001		58	
	67766	4	
	68251	54	

D3490-3	Manufactured	No	160	Each	30.0000	4	4	BE 11/10/06 B 73295 x2
Cross Bolt Spacer								

Location		Loc Qty	Loc Code
LG		30	
	70768	30	2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Wednesday, August 31, 2011 1:26:05 PM

Work Order ID: 73385

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011 **Required Date:** 9/15/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3490-1	Manufactured	No	160	Each	114.0000	4	4	BE 11/10/06

Cross Bolt Spacer

Location		Loc Qty	Loc Code	
LG		112		
	67773	5		
	69823	42		
	71841	65		4
LG001		2		
	62450	2		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73385
CL 11/08/31

RELEASED

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
   ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 1 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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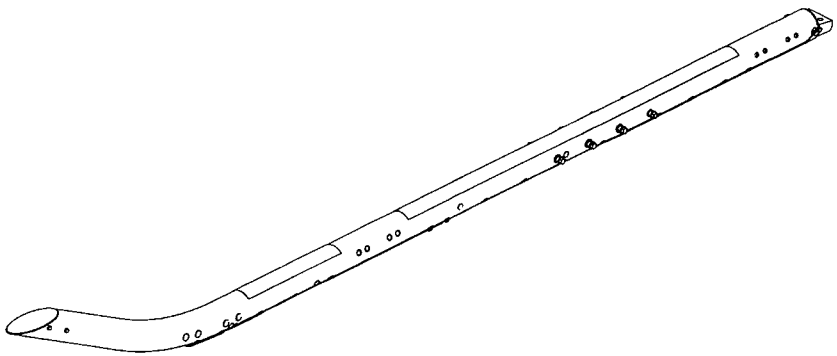
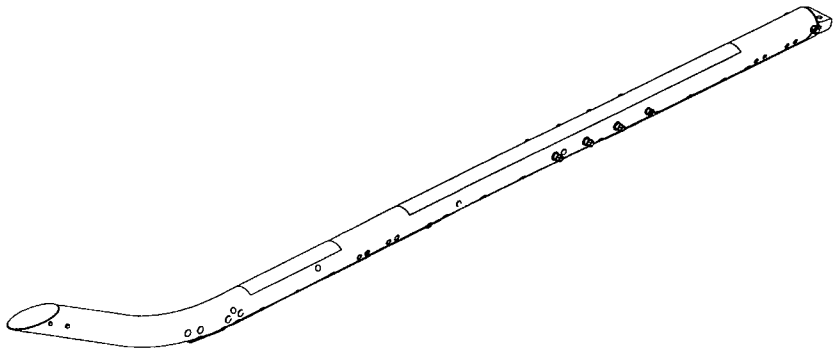


D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 2 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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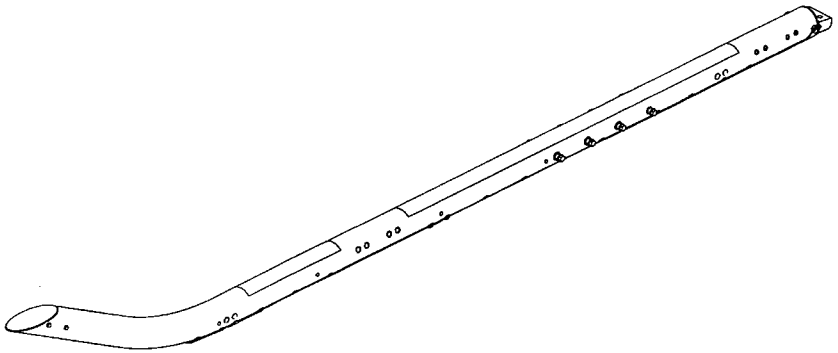
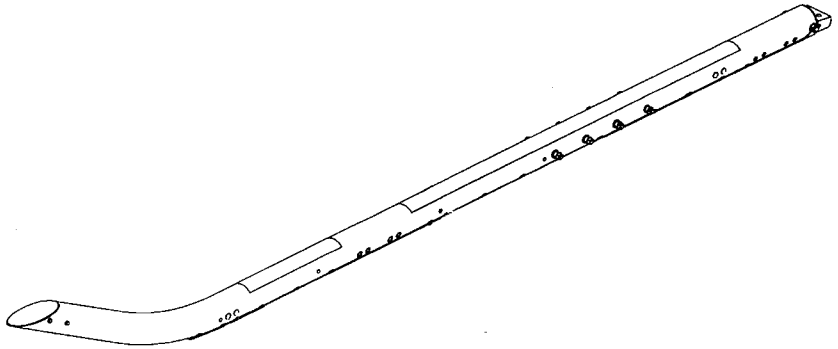


D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED 08.09.22

DESIGN	PD	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PD	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 3 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

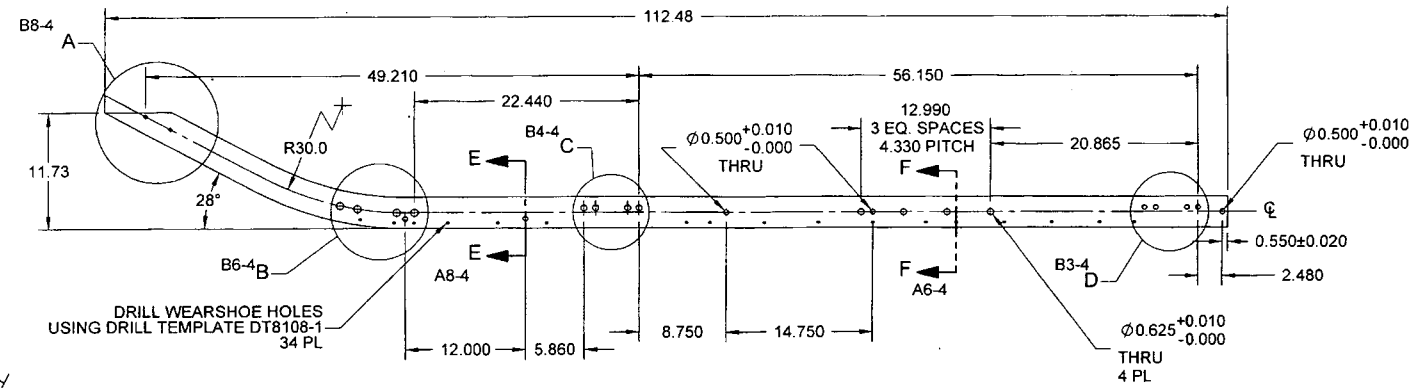
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

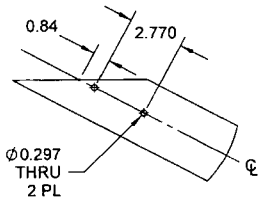
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

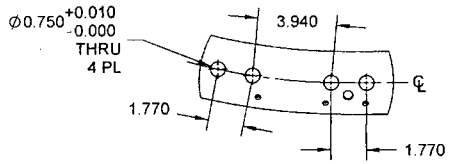
H:\FORMS\Quality Assurance\approved QA\NCRWO RevE



D2750-1 LH SKIDTUBE



DETAIL A D7-4
SCALE 2X



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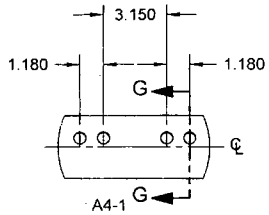

DETAIL C D5-4
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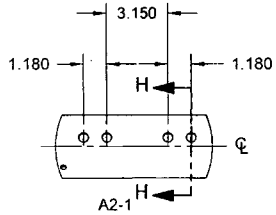

DETAIL D D3-4
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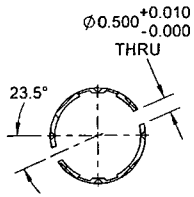
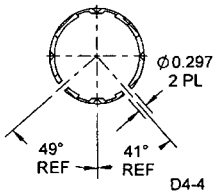
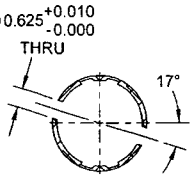


SECTION E-E D6-4
SCALE 3X, 2 PL



SECTION F-F D4-4
SCALE 3X, 17 PL



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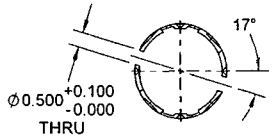
SCALE 3X, 4 PL



SECTION H-H B2-4
SCALE 3X, 4 PL

RELEASED

DESIGN	PB	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PB	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 4 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

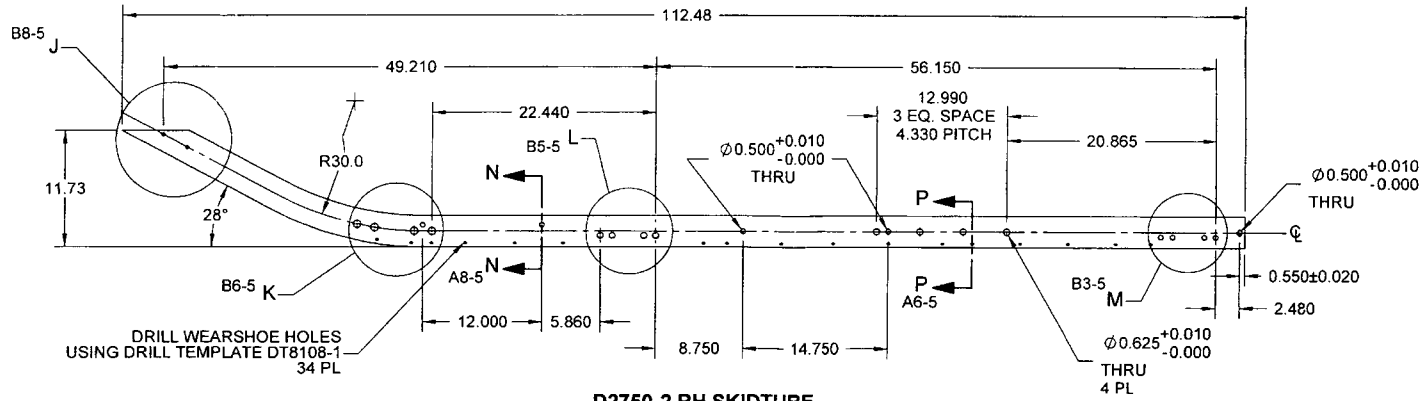
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

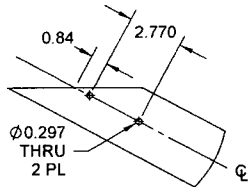
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FQRMS\Quality Assurance\approved QA\NCRWO RevE



D2750-2 RH SKIDTUBE



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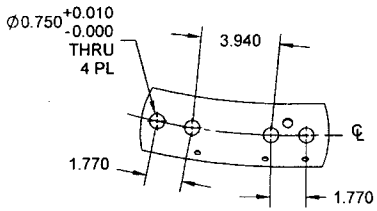
SCALE 2X



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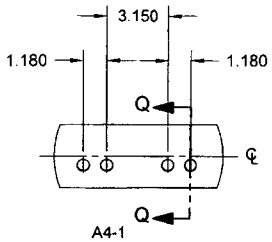

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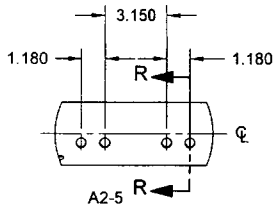

DETAIL M C3-5
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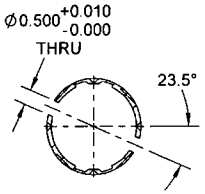
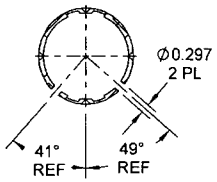
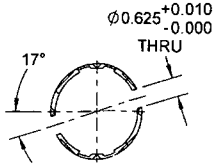


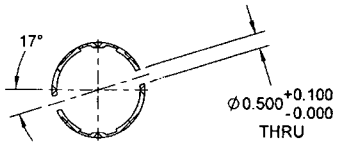
SECTION N-N C6-5
SCALE 3X, 2 PL



SECTION P-P C4-5
SCALE 3X, 17 PL



SECTION Q-Q B5-5
SCALE 3X, 4 PL



SECTION R-R B3-5
SCALE 3X, 4 PL

RELEASED
08/22/16

DESIGN	PGI	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PGI	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 5 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

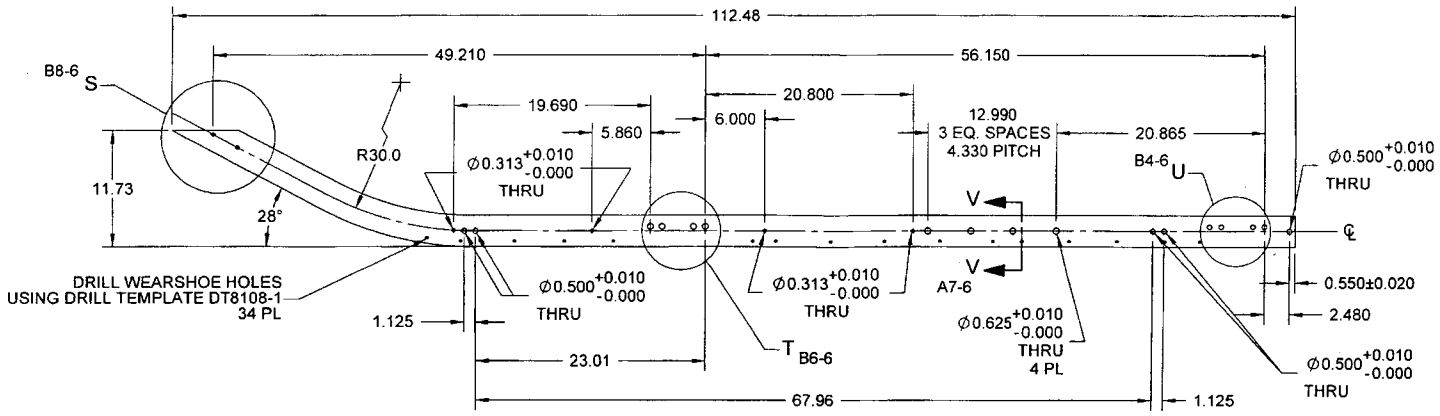
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

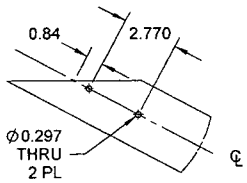
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE



D2750-3 LH SKIDTUBE



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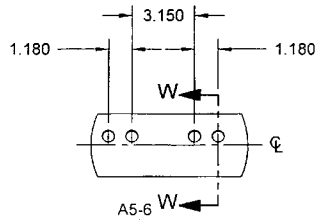
SCALE 2X



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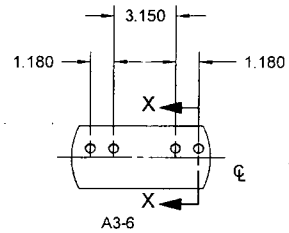

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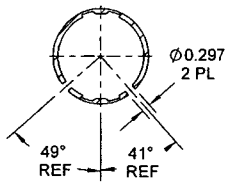

SECTION V-V C4-6
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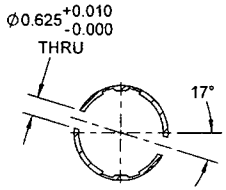

SECTION W-W B6-6
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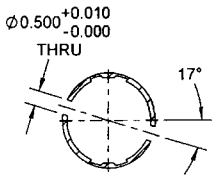

SECTION X-X B4-6
SCALE 3X, 4 PL

RELEASED

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 6 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

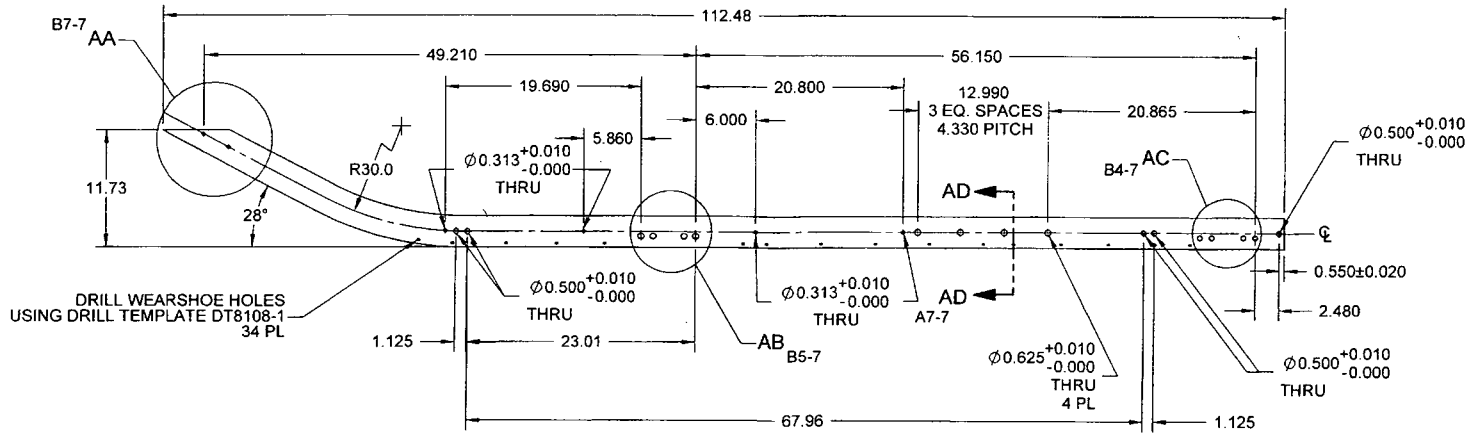
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

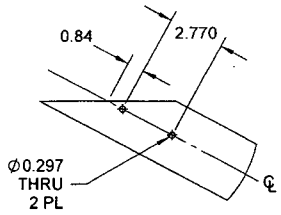
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-4 RH SKIDTUBE



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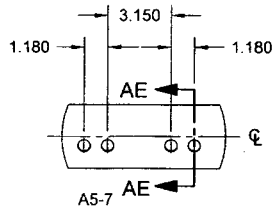

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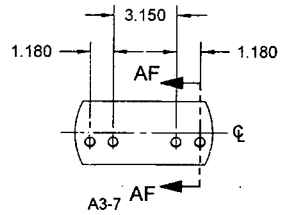

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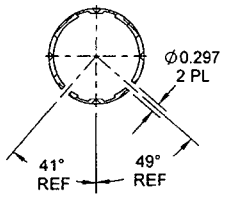

SECTION AD-AD D3-7
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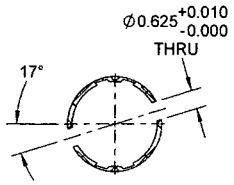
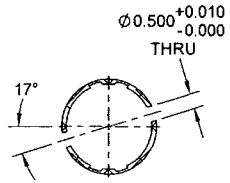


SECTION AE-AE B6-7
SCALE 3X, 4 PL



SECTION AF-AF B4-7
SCALE 3X, 4 PL

RELEASED

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 7 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

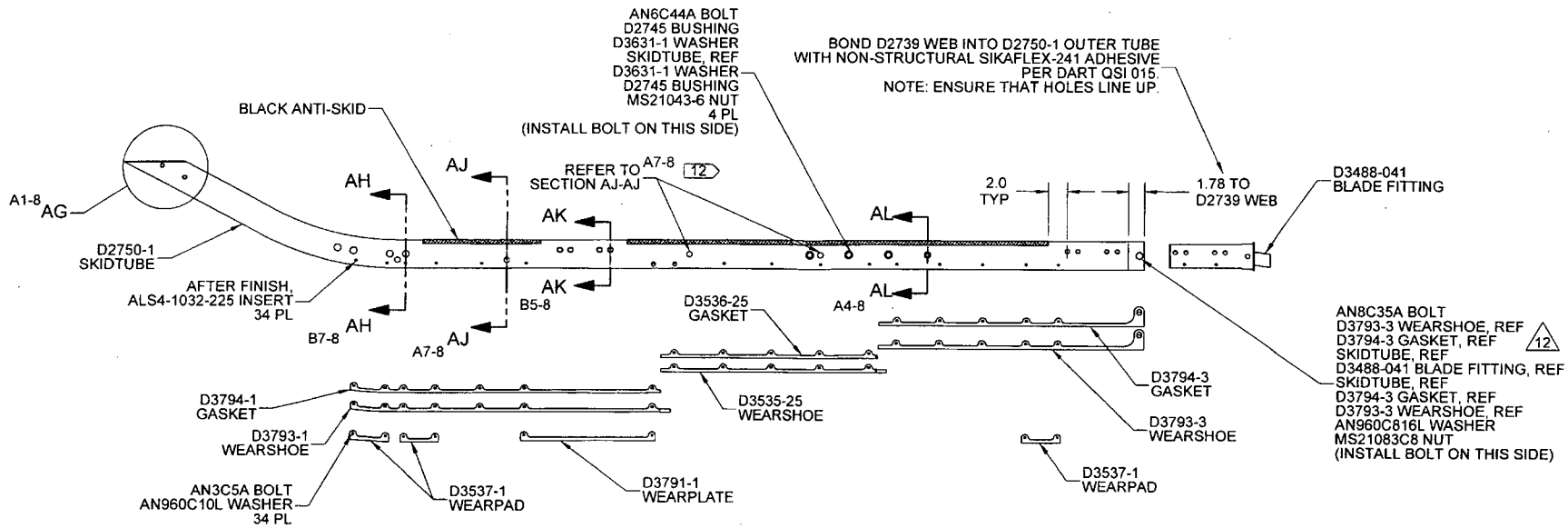
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

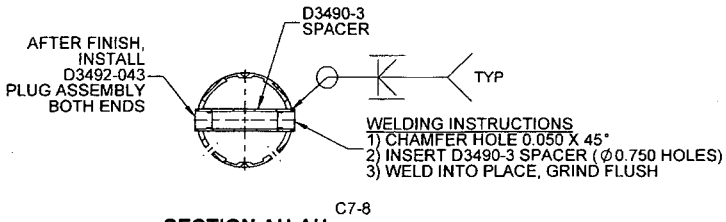
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D2750-041 350 SKIDTUBE ASSEMBLY, LH



SECTION AH-AH
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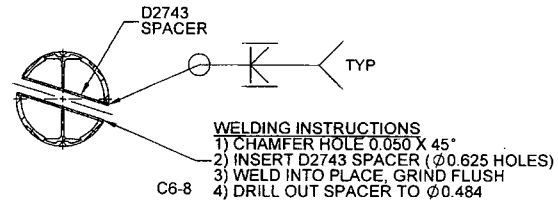

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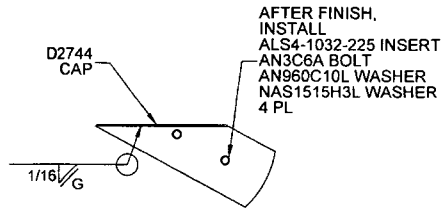
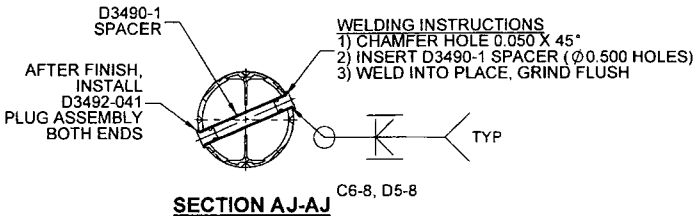
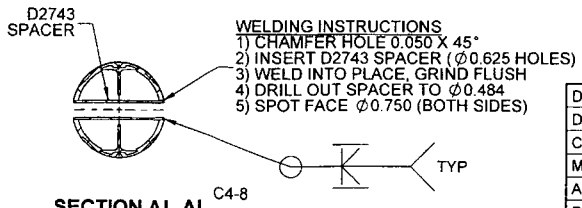


DETAIL AG
SCALE 2X
D8-8

RELEASED
08.09.22



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 8 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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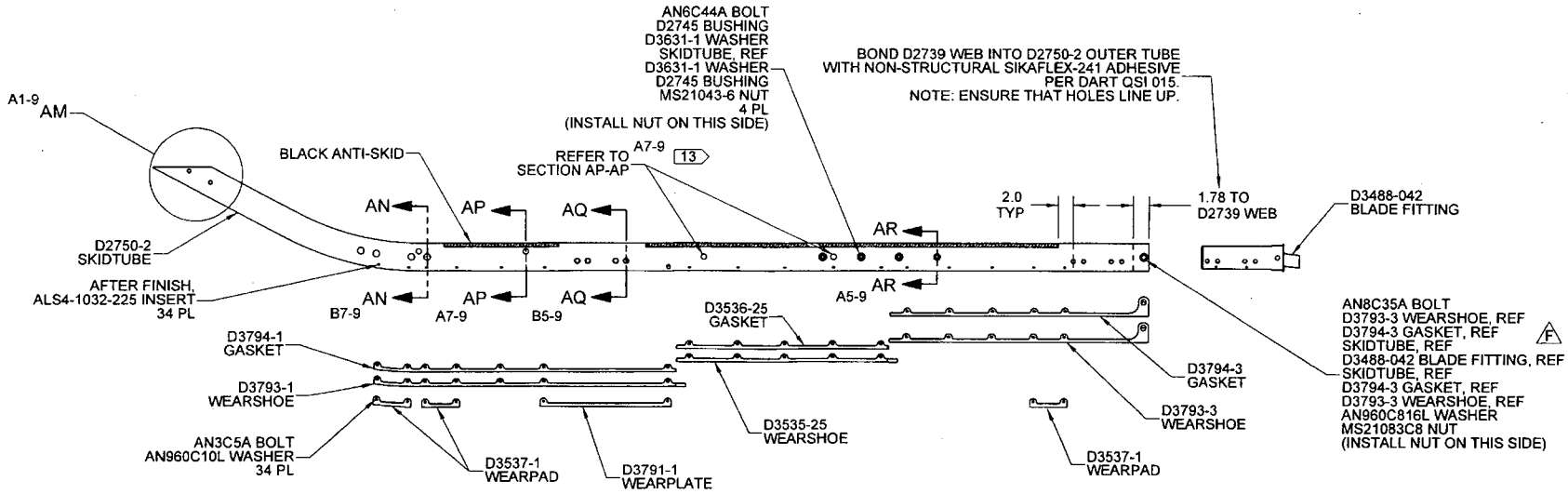
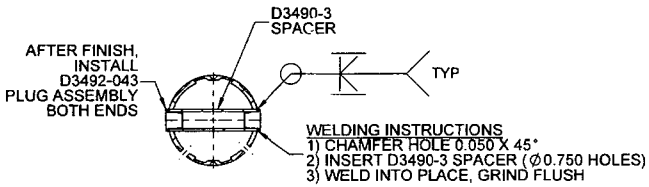
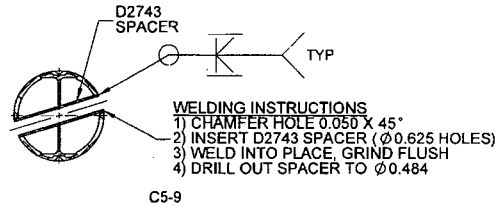


D2750-042 350 SKIDTUBE ASSEMBLY, RH



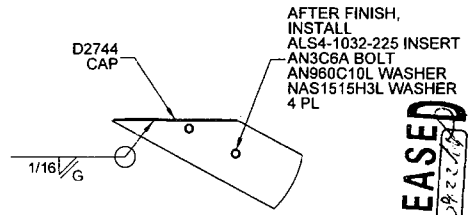
C7-9

SECTION AN-AN
SCALE 3X, 4 PL



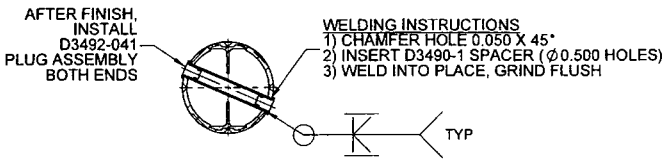
C5-9

SECTION AQ-AQ
SCALE 3X, 4 PL



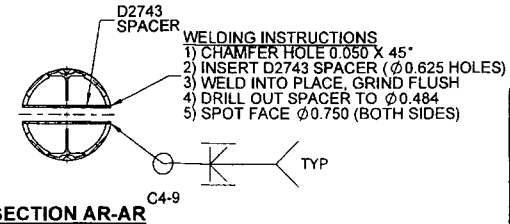
D8-9

DETAIL AM
SCALE 2X



C6-9, D5-9

SECTION AP-AP
SCALE 3X, 4 PL



C4-9

SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED 08.09.16

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 9 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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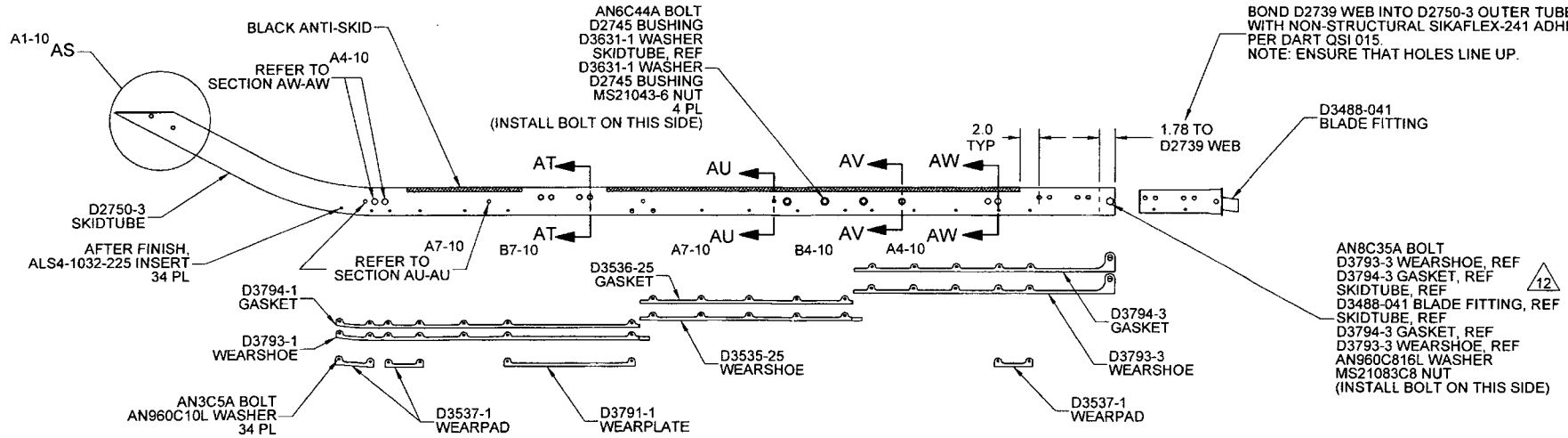
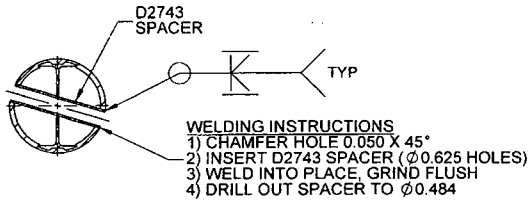
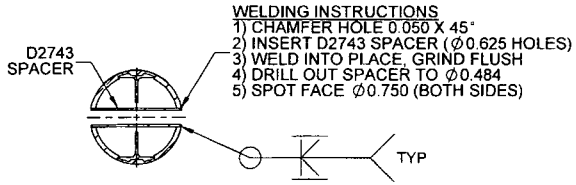


D2750-043 350 SKIDTUBE ASSEMBLY, LH



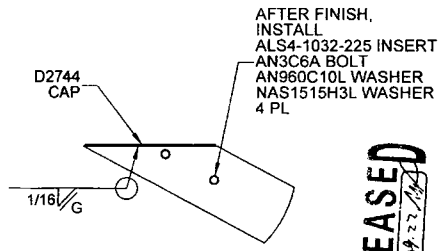
D6-10

SECTION AT-AT
SCALE 3X, 4 PL



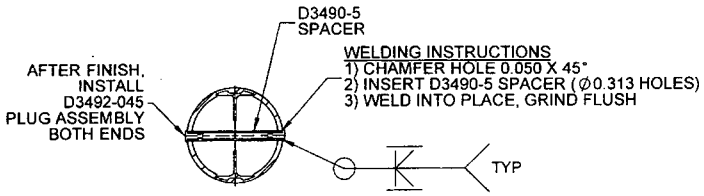
D4-10

SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



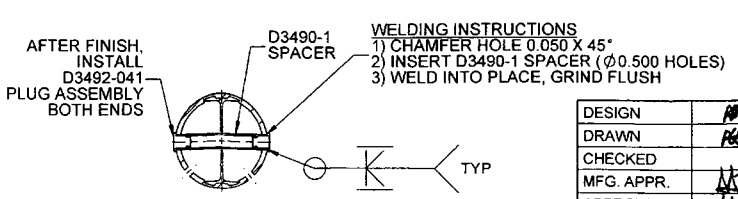
D8-10

DETAIL AS
SCALE 2X



D5-10, D6-10

SECTION AU-AU
SCALE 3X, 4 PL



D4-10, D7-10

SECTION AW-AW
SCALE 3X, 4 PL

RELEASED

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		DRAWING NO. D2750 — REV. F — SHEET 10 OF 11
CHECKED		
MFG. APPR.		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
APPROVED		
DE APPR.		
DATE	08.07.16	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE; Date & initial all entries

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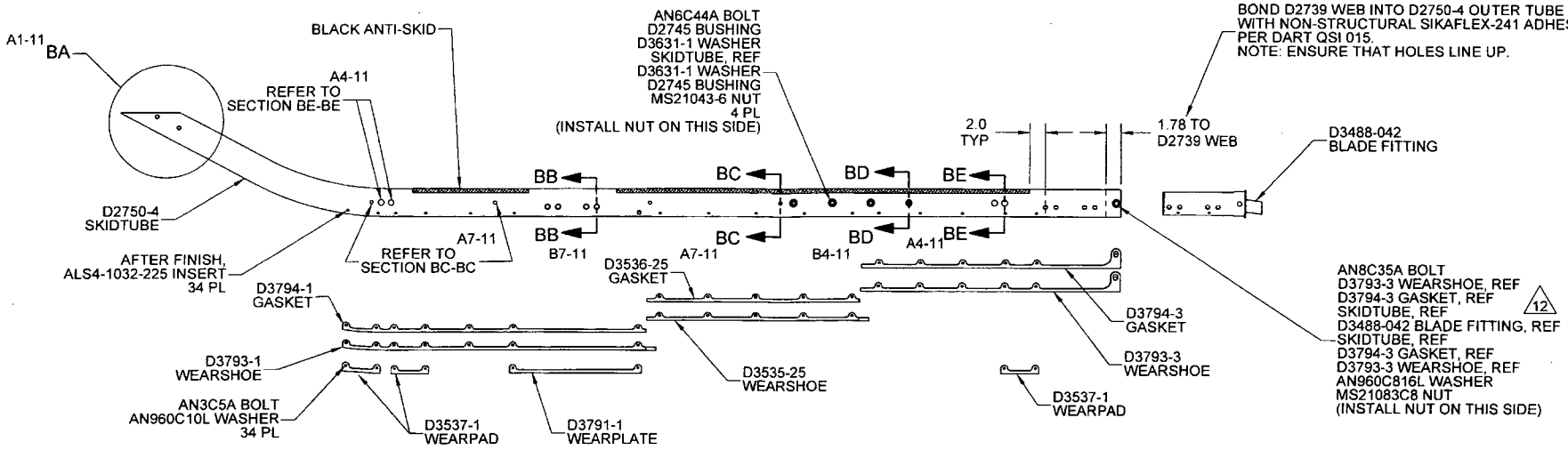
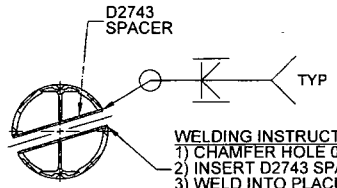


D2750-044 350 SKIDTUBE ASSEMBLY, RH

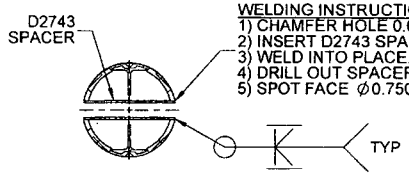
RELEASED
08.09.22



WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

D6-11

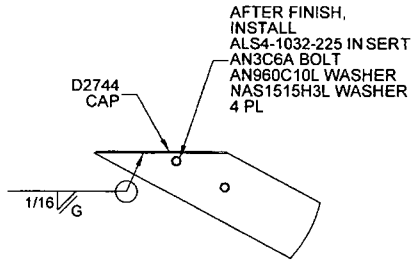
SECTION BB-BB
SCALE 3X, 4 PL



WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)

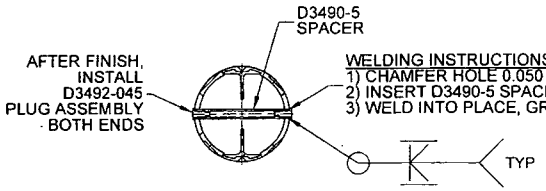
D4-11

SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



D8-11

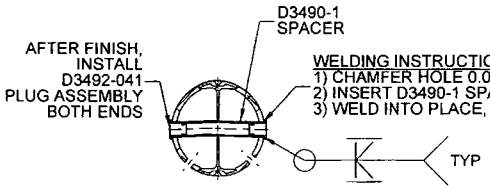
DETAIL BA
SCALE 2X



WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

D5-11, C6-11

SECTION BC-BC
SCALE 3X, 4 PL



WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

D4-11, D7-11

SECTION BE-BE
SCALE 3X, 4 PL

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 11 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
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DATE	08.07.16	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NO. 265

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 71427
Part number: 1350 636 015
Description: 350
Welding Process: Tig[X] Mig[ ]
Base materiel: Aluminum
Current: AC[X] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[X]	fail[ ]
Penetration:	pass[X]	fail[ ]

UNACCEPTABLE

Cracks:	pass[X]	fail[ ]
Undercut:	pass[X]	fail[ ]
Pin holes:	pass[X]	fail[ ]
Overlap (cold lap)	pass[X]	fail[ ]
Porosity (surface):	pass[X]	fail[ ]
Coloration:	pass[X]	fail[ ]

Qualifier [signature] **Date of Test Coupon** 11.09.06

Welder Barclay Elliott **Date of Test Coupon** 11.09.06

The above named individual is qualified in accordance with AWS D17.1.2001 to weld